

**Work Order ID 64103**

Wednesday, November 24, 2010 9:44:26 AM

**RUSH**

Page 1

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 11/24/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *10-11-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3197

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

*aml 10/11/24**2* *0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to lenght per dwg D3197□2-Machine D3197-1 as per Folio FA340  
and Dwg D3197□3-Deburr*aml 10/11/24**2* *0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*aml 10/11/24**2* *0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Lathe Conv Conventional Lathe	CONVENTIONAL LATHE  Memo Chamfer as per Dwg D3197	0.00  0.00		<i>cut 10/11/24</i>		<u>2</u>	<u>0</u>		
140  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>B.A 10/11/24</i>					
150  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1  Memo	0.00  0.00		<i>⇒ 10/11/24</i>	<i>x2</i>	<u>0</u>			

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




# Work Order ID 64103

Wednesday, November 24, 2010 9:44:26 AM

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Item ID:	D3197-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bar Assembly					
Start Date:	11/24/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	11/30/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M112588</i> Memo START TIME: <i>1:45</i> <i>320°</i> <input type="checkbox"/> FINISH TIME: <i>2:25</i> <input type="checkbox"/> OVEN TEMPERATURE:	0.00 0.00				<i>2</i>		<i>BL 10-11-25</i>	
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00		<i>=&gt; M 10/11/25</i>		<i>2</i>		<i>φ</i>	
180  Small Fab Small Fab Small Fab	Small Fab  Memo Assemble D3197-041 as per Dwg D3197	0.00 0.00						<i>EP 10/11/29 (2)</i>	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 64103**

Wednesday, November 24, 2010 9:44:26 AM

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Item ID: D3197-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bar Assembly

Start Date: 11/24/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

(P2)

10/11/29 SP (24)

OK 10/11/30

MF  
10-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



Wednesday, November 24, 2010 9:44:26 AM

[illegible]**Required Date:** 11/30/2010

**Required Qty: 2.00**

**Comments:** IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev:B As per Rev B 06-03-10 JLM

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 64103

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

M7075T73R1.000

Purchased

No

180

f

13.8000

2.42

5.094737



7075-T73 Rd Bar 1.00

Location

Loc Qty

Loc Code

MAT

13.8

→ 115165

13.8

MS21042L3

Purchased

No

180

Each

1,575.000

2



Nut

Location

Loc Qty

Loc Code

ST300

1575

114784

579

115835

996

MS27039-1-24

Purchased

No

100

Each

119.0000

2



Screw

Location

Loc Qty

Loc Code

ST292

119

100151

119

5.094 on 11/24

EB 10/11/29

4

EB 10/11/29

4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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RELEASED  
06-07-21 UP

BAR (REF)  
AN960JD1  
MS21042L  
(2 PLACE)

#64



29.00  
25.06  
11.44  
0.25  
0.500  
1.000  
0.191  
0.219 (TYP)  
0.300 FLAT (TYP, BOTH SIDES)  
2.69 FLAT  
1.000  
0.191  
0.219  
CHAMFER 0.063x45°  
Ø1.000  
Ø0.191  
Ø0.219  
DART D3197-1  
ENGRAVE DART LOGO USING 0.250 HIGH x 0.005 DEEP LETTERING AND P/N USING 0.150 HIGH x 0.00 DEEP LETTERING ON BOTH SIDES

**D3197-041 BAR ASSEMBLY**

**D3197-041 BAR ASSEMBLY**

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D.  
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER  
END OF THE BAR

DESIGN		DRAWING NO.		REV. B	
CP	CP	D3197	SHEET 1 OF 1		
CHECKED	APPROVED	DRAWING NO.	REV. B		
		D3197	SHEET 1 OF 1		
DATE	TITLE		SCALE		
06.01.10	BAR		1:1		
A	03.07.01	NEW ISSUE			
B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG			

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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